

Date: Thursday, 11/23/2006 11:54:57 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE
Job Number	: 29667		
Estimate Number	: 11545	Part Number	: D204635011
P.O. Number	: <i>N/A</i>	Drawing Number	: N/A
This Issue	: 11/23/2006 S.O. No. : <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: N/A
First Issue	: <i>N/A</i> Type : LANDING GEAR	Material	: <i>N/A</i>
Previous Run	: 29666	Due Date	: 12/12/2006 Qty: 1 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 06 11 23		
Comment	: Est Rev: G02.08.28 Removed QC5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011 CHG004

*KS 06 11.28*

2.0	29667A	SKIDTUBE
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Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	<i>B29667A</i>

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<i>B29768</i>

*[Signature]* 02/09  
*[Signature]* 02/09

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

*[Signature]* 02/09  
*[Signature]* 02/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 07/02/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:54:57 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29667

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location:

PPP Rev: B

FINAL INSPECTION/W/O RELEASE

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*in 070209*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:55:24 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE  
 Job Number : 29667A  
 Estimate Number : 11546  
 P.O. Number : N/A Part Number : D204635041  
 This Issue : 11/23/2006 S.O. No. : N/A Drawing Number : D2590 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 29666A Material : N/A  
 Due Date : 12/12/2006 Qty: 1 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est Rev: F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001190 Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion *24669*

*Pmc*  
*JD 06/11/00*

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2597 204 Web *28802*

*Pmc*  
*JD 06/11/01*

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

*Pmc*  
*JD 06/11/30*

2-Cut D2500-1-190 per Dwg D2590 .Debur ends

*Pmc*  
*JD 06/11/30*

3-Drill pilot holes using drill jig DT 8149 & DT8711-1&2

*Pmc*  
*JD 06/11/30*

4-Acid etch and Alodine tube per QSI 005 4.1

*Pmc*  
*JD 06/11/30*

5-Open holes to 0.500" as per Dwg D2590 without cutting fluid

*Pmc*  
*06-11-30*

6-Countersink holes as per Dwg D2590 without cutting fluid

*Pmc*  
*06-11-30*

7-Debur and blow out all chips from inside of tube

*Pmc*  
*06-11-30*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:55:25 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29667A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
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A/R	Sikaflex-291	M 102 107	5P 06/12/01
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Sikaflex expire date: 07-02-01

Start Time: 9:00

Fin Time: 11:00 6-12-4

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

DP 6-12-4

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590.

DP 6-12-4

5P 06/12/05

2-Deburr ends after cutting. Remove alodine from around holes

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-12-08

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2576-3	Step	B 29486 BE 06-12-11
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8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

17	D2579	Spacers	B 29603 BE 06-12-08
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29667A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 06-12-08

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

M101446

BE 06-12-11

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M101446

BE 06-12-08

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending

JP/PM 06-12-12 (1)

5-Drill holes for wearplates using DT 8218 Open holes to 19/64", adjust stopper not to hit crosstubes. Deburr

PM 06-12-12 (1)

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes

PM 06-12-12 (1)

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

PM 06-12-12 (1)

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

PM 06-12-12 (1)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MOG/2/13 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jac-12-12 (1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

YR 07/01/23

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

27/01/24 (1)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 20 Date: 07/02/12.  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.01.19	12.0	Oil marks in a few holes at the saddle holes location.	2 QS1042	Remove Powder coat & oil, wash with wash & wipe to ensure tube is clean & re powder coat as per QS1 005.	4/1 07/01/19	07/01/19	2 QS1042	07-01-19

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 29667A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	29488

15.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	29326

16.0

D25777

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-7	Wearplate	21607

17.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-1	Plug	29490

18.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
10	D2594-3	Plug	27168

YD 07/01/25

O-ring

BC

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

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Drawing Name: SKIDTUBE

Job Number: 29667A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Cap 27488

20.0

ALS71032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)  
Pick:

Qty	Part Number	Description	Batch
38	ALS7-1032-130	Inserts	<u>102475</u>

21.0

AN960JD10L

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)  
Pick:

Qty	Part Number	Description	Batch
8	AN960JD10L	<del>inserts</del> washer	<u>102217</u>

22.0

AN34A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)  
Pick:

Qty	Part Number	Description	Batch
38	AN3-4A	Bolt	<u>103154</u>

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt 15205

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2590. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

yl  
07/01/25

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:55:25 AM  
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## Process Sheet

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Drawing Name: SKIDTUBE

Job Number: 29667A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 02/07

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

M102098

MB/YL

Batch:

07/01/25  
07/01/26

25.0

QC5

INSPECT WORK TO CURRENT STEP



07/02/06

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

26.0

QC21

FINAL INSPECTION/W/O RELEASE



07/02/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U, 07-02-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. C SHEET 1 OF 2
DATE 98.08.28		TITLE 204 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/11 DS

QTY	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2597	204 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG /
10	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-7	WEARSHOE
38	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
40	AN3-4A	BOLT
40	AN960JD10L	WASHER

# 98.08.28  
98.08.28

DEOS  
EFFECTIVE  
98/12/14

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 169.5 INCHES \*
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (38 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2597 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (10 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29667A

Diagram illustrating the grinding locations on a propeller cross-section. The diagram shows a cross-section of a propeller with the following labeled areas:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH
- GRIND FLUSH

Diagram illustrating the installation of the D2575 CAP on the AN960J10L washer. The diagram shows a cross-section of the washer and the cap. The cap is labeled "D2575 CAP". The washer is labeled "AN960J10L". The cap is secured by a bolt labeled "AN3-4A BOLT (1)" and a washer labeled "AN960J10L WASHER (1)". The cap is sealed with SIKAFLEX-241. The diagram also shows the "D2575 CAP" and the "AN960J10L WASHER (1)".

D2579 SPACER

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB  
3  
7  
1.750  
1.750  
90.508 (TYP.)  
(34 PLACES)  
REFER TO DETAIL A  
REFER TO DETAIL A  
8.750  
17.375  
26.000  
35.000  
36.000 (REF)  
4 EQUAL SPACES  
9.00 PITCH  
38.0  
71.000  
169.5  
(D2500-1)

D2590-041 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

REFER TO DETAIL C


AN3-4A BOLT (1)  
AN960J010L WASHER (1)  
(38 PLACES)

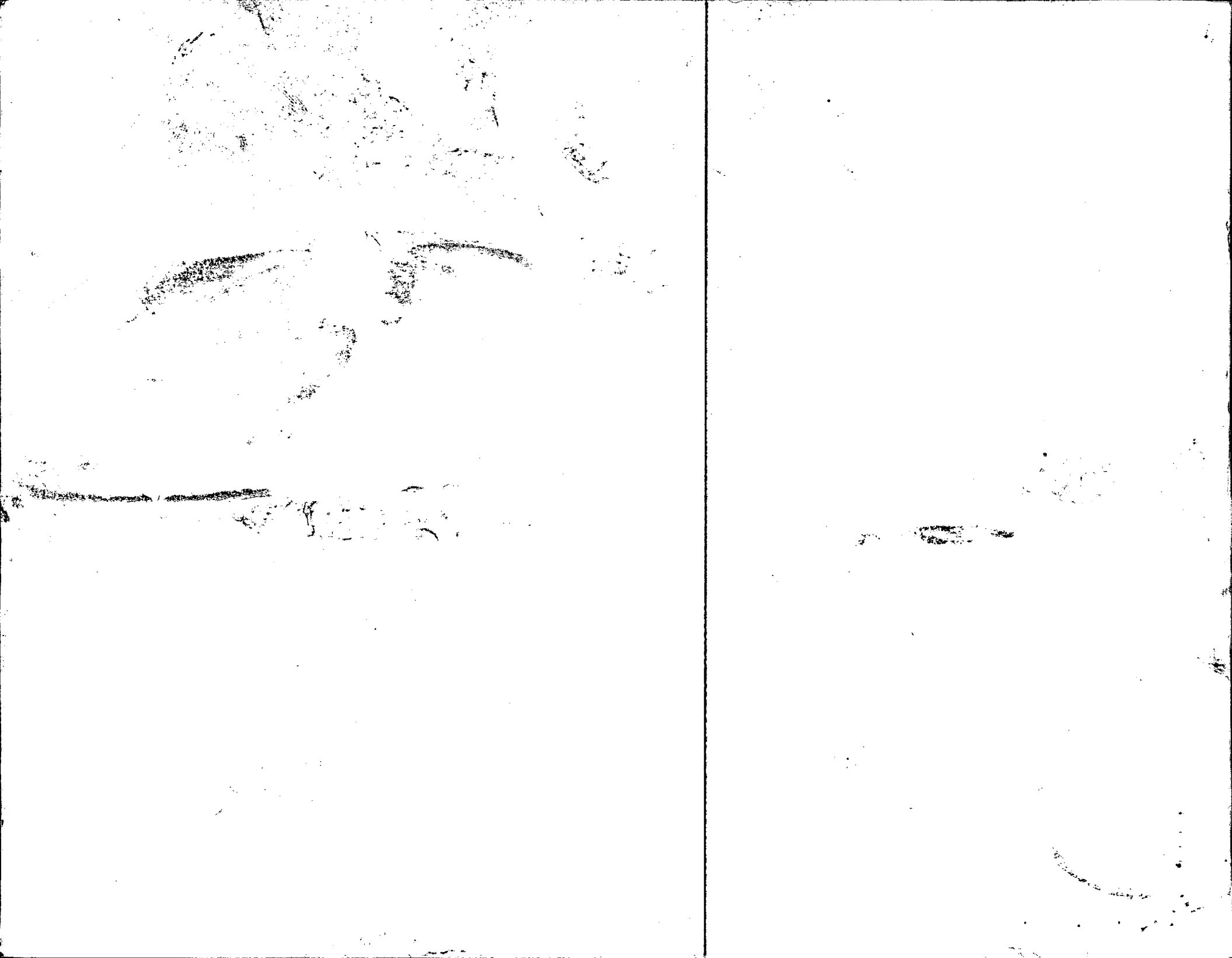
D2577-3

D2577-7

D2577-1

8

DESIGN <i>DA</i>	DRAWN BY <i>CP</i>	 <b>DART AEROSPACE LTD</b> MARKHAM, ONTARIO, CANADA
CHECKED <i>DA</i>	APPROVED	
DATE 98.08.28	DRAWING NO. <b>D2590</b>	
	TITLE <b>204 SKIDTUBE ASSEMBLY</b>	
	REV. SHEET 2 OF SCALE <b>1:2</b>	



NO. 81

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott

Joint Welding Procedure Tig

Part number and Job number D204 635 041 / B29664 A

TEST WELDS REQUIRED

BASE METAL Aluminium

WELDING PROCESS Tig

Penetration Complete ☐ Partial ☒

Single Weld ☒ Double Weld ☐

Current AC ☒ DC ☐

Backing YES ☐ NO ☒

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into

Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐

Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☒ Fail ☐

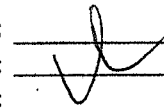
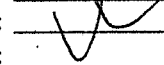
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06-12-08

Qualifier Pat. D. N.

Date: Tuesday, 28/08/2007 12:40:11 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: UPDATE PAPERW. 634/635
Job Number	: 34285		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: Z_CUSTOM
This Issue	: 28/08/2007 S.O. No. : N/A	Drawing Number	: ECN 1023
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 04/09/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK / ADD NEW PAPERWORK

EASA STC: EASA.IM.R.S.01303

B 32851, B 32854, B 32953, B 32951, B 32952, B 32212,  
 D205-634-011 B 32613, 32618, B 32950, B 32615, B 32853, B 32213, B 32215

D205-634-041

D205-635-011 B 29278, B 29667, B 29955, B 29956, B 29957, B 29959

73 D205-635-041 B 21564, B 21821, B 22797, B 20000

D205-634-043

D205-634-045 B 12245  
 D519372-011 B 33404  
 RETURN TO STK

Date: Friday, 09/02/2007 9:59:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-635 / D204-635
Job Number : 30722	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z-CUSTOM ECN952/908
This Issue : 09/02/2007 S.O. No. : N/A	Drawing Number : UPDATE PAPERWORK
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : OVERHEAD	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 16/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563N4

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

*voir papier  
 avec ✓*

*7/4/27 SQ*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 RETURN TO STOCK

*7/4/27 SQ*